

Work Order ID 66047

Thursday, February 03, 2011 8:42:10 AM



PRELIMINARY ISSUE

Page 1

Item ID: D4198-5

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Bellcrank

Start Date: 2/4/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 2/28/2011 Req'd Qty: 2.00



Customer:



Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4198	PA1 PA2 11/02/15

100		0.00							
	Bandsaw								
Jeaspa Bandsaw	Memo CUT 3.175" LONG	0.00							

110		0.00							
	HAAS 1								
HAAS CNC vertical machine #1	Memo MILL AS PER DWFG AND FOLIO FA993 FOLIO REV: AA DWG REV: PA2	0.00							

DEBURR .015-.030

DRILL HOLES MANUALLY USING 4 JAW CHUCK ON 4TH AXIS

2 1 Pto →

W/O: 66047		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 4198-5 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/02/15	110	1st part shifted in vice while trying to fit jig in part for second operation RC. Tolerance too small in jig	CP 11.02.28 QSI/HL	Jig has been oversized by .002" B.A. 11/02/16 Ø.1.00" Dim measured .0.975" Scrap + Destroy + Replace	B.A. 11/02/15		CP 11.02.28 QSI/HL	S 11/02/22
		Tooling has was was made wrong-	CP 11.02.28	Qty x1 m 116172			CP 11.02.28	S 11/02/22

NOTE: Date & initial all entries

Work Order ID 66047

Thursday, February 03, 2011 8:42:10 AM



Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

A.A 11/02/15

2

0

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Jas 11.02.28

2

0

Quality Control

140

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

0.00

B 66205
B 66204

SB 11/04/20

2

Packaging

Work Order ID 66047

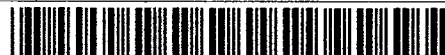
Thursday, February 03, 2011 8:42:10 AM



Page 3

Item ID: D4198-5

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Bellcrank

Start Date: 2/4/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 2/28/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11-06-9
②

POSITIVE RECALL

EFFECTIVE

11-02-04

AUTH

U

RELEASED

DATE

Picklist Print

Page 1

Thursday, February 03, 2011 8:42:05 AM

Work Order ID: 66047



Parent Item: D4198-5



Parent Item Name: Bellcrank

Start Date: 2/4/2011

Required Date: 2/28/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-11-03 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B1.250X03.500		Purchased	No			100	f	3.4380	0.26666	0.561389			



303 BAR 1.250" X 3.500"

Location

Loc Qty

Loc Code

MAT

3.438

→ 116172

3.438

0.5613^{ft}

B.A 11/02/15

+ 0.2806^{ft}

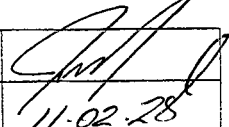
DART AEROSPACE LTD		Work Order: 66047
Description: BELLCRANK		Part Number: D4198-5
Inspection Dwg: D4198 , Rev: PA2		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☒ Prototype

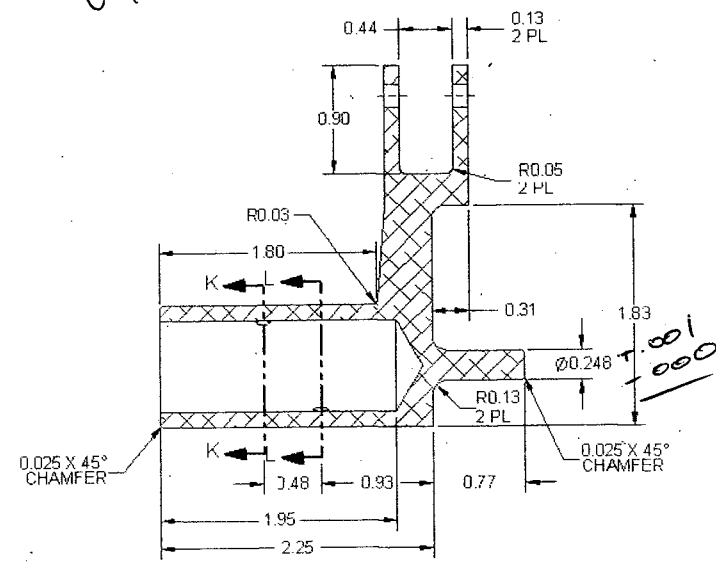
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.25	+/- .030	R0.250	✓		R-G	ref.
2.23	+/- .030	2.230	✓		H-G	31006
φ0.800	+0.10 / - .001	φ0.7995	✓		Mic	GA-03
φ1.000	+0.00 / - .002	φ0.9998	✓		"	"
φ0.195	+0.005 / - .001	φ0.199	✓		Vern	GA-01
0.13	+/- .030	0.126	✓		"	"
0.44	+/- .030	0.439	✓		"	"
0.90	+/- .030	0.902	✓		H-G	31006
R0.03	+/- .030	R0.030	✓		R-G	ref.
1.80	+/- .030	1.800	✓		H-G	31006
0.025x45°	+/- .010	0.025x45°	✓		Vern	GA-01
2.25	+/- .030	2.250	✓		"	"
1.95	+/- .030	1.942	✓		"	"
0.48	+/- .030	0.480	✓		H-G	31006
0.93	+/- .030	0.930	✓		"	"
0.77	+/- .030	0.769	✓		D-G	GA-08
R0.13	+/- .030	R0.125	✓		R-G	ref.
φ0.248	+0.001 / -0.000	0.2480	✓		Mic	GA-03
1.83	+/- .030	1.826	✓		H-G	31006
0.31	+/- .030	0.306	✓		D-G	GA-08
R0.05	+/- .030	R0.050	✓		R-G	ref.
15°	+/- 1/2°	15°	✓		Angle protractor	ML CBB
φ0.125	+0.004 / - .001	φ0.1250	✓		Mic	GA-03

Measured by:	JA
Date:	11/02/15

Audited by:	
Date:	11-02-28

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



SECTION L-L

10.11.03

- [Signature]*

DESIGN	1	DART AEROSPACE LTD	
DRAWN	1	14MMESSBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA2
MFG. APPR.		D4198	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		THROTTLE BELLCRANK	NTS
DATE	10.11.03	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY AND CONTENTS ARE SHARED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR COPIED OR OTHERWISE USED FOR ANY OTHER PURPOSE WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

Receiving Report

Date: 10/11/17 Batch No: M116172
 Supplier: MetAUX CASTLE Part P/O: 12898

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒
 Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☐ No ☒
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection ☒ N/A ☐
 Work Order ☐ N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Production/Admin.
 Date 10/11/17
 Received/Costing
 Initial

Location

FROM Acier Campi

(MON) NOV 1 2010 11:45/ST. 11:44/No. 7523655887 P 1

ACIER CAMPI INC.

935 Boul. du Havre

Valleyfield, Quebec J6S 5L1

Tel: (514) 336-4248 (MTL)
(450) 377-4248
(800) 667-4248

Fax: (514) 336-4246
(450) 377-5696

(F) 613-632-1053

(T) 613-632-5200

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY,
ONTARIO
K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY,
ONTARIO
K6A 1K7

QUOTE 271903

DATE
01/11/10

DELIVERED
01/11/10

Client code	Rep	Conditions	Page
DAER	D	NET 30 JOURS	001

Description	Quant.	Weight	Price	By	Ext. Price
-------------	--------	--------	-------	----	------------

CHANTAL
I'M SENDING YOU A FAX
BECAUSE OUR INTERNET
CONNEXION IS DOWN

SS304 1.25" X 3.5" X 48"	1	1	265.000		265.00
--------------------------	---	---	---------	--	--------

SORRY, NO 303

THANK YOU, DENIS

Total weight	1	Sub-total	265.00
		GST	0.00
		PST	34.45
		TOTAL	299.45

IMPORTANT: This offer is based upon the availability and the actual price of the material which may be revised upon reception of the order.

Prices are valid for 15 days

Please send a reply to accept this quote.

Purchase Order Receipt Listing

Wednesday, November 17, 2010 3:22:57 PM

Page 1 of 1

All amounts are calculated in domestic currency.

All Vendors PO ID PO12848 Receipt Dates from 11/17/2010 to 11/17/2010 All Line Item Types
All Item ID/GL/WOs All Rec. Employees All Currencies
Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Vendor Name		VC-MET001	Metaux Castle								
PO12848	1		M303B1.250X03.500 f		11/2/2010	11/17/2010	4.0000				
CAD	No		303 BAR 1.250" X f		4.0000	DLSJ02		\$184.00	0.0000	0	\$736.00
			3.500"					\$736.00	0.0000	0	
			116172								

**Castle Metals®**

A. M. Castle & Co.

BORDEREAU DE MARCHANDISES

Page 1 of 1

No de Formulaire d'Emballage / Shipment No: 571919

Expédié de / Ship From: Castle Metals MONTREAL 835-SELKIRK AVENUE POINTE CLAIRE, QUEBEC H9R 3S2		Vendu à / Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7		Expédié à / Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7		Livré à / Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date d'expédition / Date Shipped 16-NOV-10	F.O.B. ORIGIN	Modalités de transport / Freight Terms Prepaid		Transporteur / Carrier UPS		N° du Bon de connaissance / BOL No 571919-2	

Détails d'expédition / Shipment Details	Destination finale / Final Destination Branch - MON
--	--

N° de commande / Order No 1092013	N° de ligne / Line No 1	N° d'article / Item No 63431.BO	Description 1.2500.3.5000.FLAT.303.STAINLESS.144.0000
---	-----------------------------------	---	---

N° de bon de commande / Purchase Order No 12848	Nbre de pièces / Part Number	Qté commandée / Ordered Qty 1 PCS	Qté Facturée / Invoice Qty 1 PCS
---	-------------------------------------	---	--

Détails / Details							
N° de livraison / Delivery No : 56493306	Usine / Mill	No de coulée / Heat Number A10957	Code méc / Mech Id	Pièces / PCS 1.0	Largeur (Pouce) / Width (IN)	Longueur (Pouce) / Length (IN) 48	Qté expédiée / Shipped Qty (LBS) 60

Ces marchandises/technologies sont sujettes aux règlements de l'Export Administration et du département d'état des États-Unis. Si elles ont été exportées, elles doivent se conformer à ces règlements. Toute modification du contrat de transport contraire aux lois des États-Unis est interdite.

These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, are to be exported thereunder. Diversion contrary to US Law is Prohibited.

Nous certifions par la présente que le matériel couvert par cette certification est conforme aux spécifications susmentionnées et aux exigences applicables pour le matériel, y compris toute spécification faisant partie de la description. Les rapports d'essai sont archivés pour fins de consultation. Toute requête concernant du matériel défectueux sera rejetée à moins qu'elle ne soit faite par écrit à A. M. Castle & Co. dans les 60 jours suivant la livraison. Le matériel coupé sur mesure ou coupé par le client ne peut être retourné pour crédit.

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.

Ce matériel a été reçu et inspecté par
Reviewed by Authorized Castle Metals Representative:

Date:



Case 63431 Bo Po 8780 1/

**S
H
I
P** FRY STEEL COMPANY
13325 MOLETTE ST
SANTA FE SPRINGS, CA 90670

OUR ORDER NO.
P5-11977-9-01

DATE
02/01/10

**SHIPPED FROM
SYRACUSE**

CUSTOMER ORDER NO
45726-18/S29290

CUSTOMER REQ NO

**DISTRICT
B PARSONS**

DESCRIPTION OF MATERIAL

CRU 303 PLUS HRAP S#29290

SIZE

3.500 X 1.250

MIL-S-7720 AMEND 1 QQS-763C COND A 3.500 X 1.250
(OBSOLETE) ASTM-A582-05 ASTM-A320-08 GR B8F CL 1 AMS-5640U TYPE 1 (EX FIN)
EN 10204 3.1, 2004
DFARS 252.225.7014 ALT 1 AND 225.7002-3 (B) (1) COMPLIANT

HEAT NO.

A10957

CHEMICAL ANALYSIS

C	MN	P	S	SI	NY	CR	MO	CU
.062	1.62	.035	.31	.55	8.19	17.18	.38	.33

QUANTITY	HEAT NO.
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1	2
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1	98
1	99
1	100

MECHANICAL PROPERTIES

2096 # A10957

TENSILE PSI	YLD.2&PSI	%ELONG4D	RED/AREA4	HARDNESS
89,170	37,180	63.6	63.2	BBN 153/ 150

1 BDL

MACRO TEST OK

MICRO TEST OK

"THE RECORDING OF FALSE, FICTITIOUS OR FRAUDULENT STATEMENTS OR ENTRIES ON THIS DOCUMENT MAY RESULT IN PUNISHMENT OR DISMISSAL."

FRY STEEL CO. CERTIFIES THAT THIS IS
A TRUE COPY OF THE ORIGINAL MILL TEST
REPORT NOW ON FILE
RECEIVED AND INSPECTED

FEB 08 2010

CASTLE METALS - MTL

DATE REC'D 11-12-10

LOT No. M 98932

OF PAGES (OMTR ONLY) 1

APPROVED BY _____

AY

GHP SANDOVAL - O.G. MANAGER

MATERIAL FREE FROM MERCURY CONTAMINATION AT TIME OF SHIPMENT. NO WELD REPAIR PERFORMED. MATERIAL MELTED AND MANUFACTURED IN U.S.A. PRODUCTS, TECHNICAL DATA, TECHNOLOGY, AND SERVICES OF CRUCIBLE INDUSTRIES LLC ARE SUBJECT TO U.S. EXPORT CONTROLS UNDER THE APPLICABLE LAWS AND REGULATIONS OF THE UNITED STATES. CRUCIBLE PRODUCTS AND/OR TECHNOLOGY MAY NOT BE EXPORTED OR RE-EXPORTED, EITHER DIRECTLY OR INDIRECTLY, TO ANY EMBARGOED COUNTRIES OR TO ENTITIES AND PERSONS THAT ARE INELIGIBLE TO RECEIVE SUCH PRODUCTS OR INFORMATION UNDER U.S. LAW.

THE ABOVE MATERIAL WAS MANUFACTURED AND TESTED ACCORDANCE WITH ABOVE SPECIFICATIONS AND IS IN CONFORMANCE WITH THE SPECIFICATION REQUIREMENTS.

CERTIFIED BY

WILLIAM E MASTROE-MANAGER QUALITY ASSURANCE



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO12848**

Purchase Order Date 11/02/10

PO Print Date 11/02/10

Page Number 1 of 1

Order From :

VC-MET001

METALUX CASTLE

A.M. CASTLE & CO. (CANADA) INC. - BOX B9204 PO BOX 9100

TORONTO, ON M4Y 3A5

CA

Contact Name

Vendor Phone

514 694 9575

Vendor Fax

514 695 3281

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

CANADA

FAKED
Photocopy

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M303B1.250X03.500	303 BAR 1.250" X 3.500"	11/02/10 Yes	✓ 4.00 f	Yours ppd	\$184.0000	\$736.00

Special Inst: MATERIAL: AISI 303 SS BAR
NOTE: AISI 304/316 NOT ACCEPTABLE

PO Total:

\$736.00

11/11/10

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

u *cd*

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 11/02/10

SPECIFICATION CONTROL DRAWING

REFERENCE ONLY

PURCHASE MATERIAL: AISI 303 SS BAR
(NOTE: AISI 304/316 NOT ACCEPTABLE)



SPECIFICATION: ASTM A582

PART NUMBER: M303B | T.TTT | XWWW.WWWW |
THICK | WIDTH

WHERE "T.TTT" = THICKNESS IN INCHES
AND "WWW.WWWW" = WIDTH IN INCHES

EG. 0.5" x 3.0" BAR = M303B0.500X03.000

RELEASED
2010-02-02

B	REFORMAT DWG. ADD SPECS (ZN DS-1).	CP	10.01.05
A	NEW ISSUE	DS	02.05.29
REV	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		M303B	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		303 BAR	NTS
DATE	10.01.05	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIAL. IT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR THE PURPOSES OF WHICH IT WAS ISSUED AND NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.</small>	

Chantal Lavoie

From: Desbiens, Marc [mdesbien@amcastle.com]
Sent: November 1, 2010 3:34 PM
To: Chantal Lavoie
Subject: RE: quote

Hi Chantal,

price & delivery

303 bar 1.25" x 3.50" x 4 ft

\$ 736.00 Lot 2 weeks

Thanks

This E-mail may contain proprietary information and may be confidential. You are to treat this material in accordance with your company's confidentiality policies and limit any distribution accordingly. If you are not the intended recipient of this E-mail, you are hereby notified that any dissemination, distribution or copying of this message is strictly prohibited. If you received this message in error, please delete it immediately.

11/02/10

TRANSMISSION VERIFICATION REPORT

TIME : 11/02/2010 09:24
NAME :
FAX :
TEL :
SER.# : F9N212739

DATE, TIME	11/02 09:23
FAX NO./NAME	15146953281
DURATION	00:00:18
PAGE(S)	01
RESULT	OK
MODE	STANDARD
	ECM